

NAR-19-7737



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6798860-4
Job Sheet 200570



Part No: RB6798860-4

Job Qty: 6 pcs

Part Name: Bridge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 11/14/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RB6798860 Rev 2 IPP Rev. A 19.09.12 New issue DP Verify DD

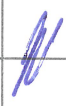
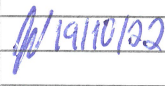
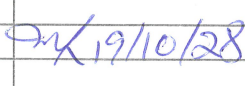
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	6 pcs		11/14/19	0.17	2.00	Waterjet - Omax		09/19/10/10
110	QC 2	6 pcs		11/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		09/19/10/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Conventional Mill - 1 - B4B	6 pcs	11/14/19	0.25 3.00	Conventional Mill - 1 - B4B	
					Conventional Mill - 2 - B4B	
130	QC 2	6 pcs	11/14/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	6 pcs	11/14/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	

					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
150	Outsource - 13 - Zinc Plating	6 pcs	11/14/19		GRO002-VC	2019-11-04
160	Packaging 2-1 - Receive - B4B	6 pcs	11/14/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP NOV 07 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	

170 QC 6	6 pcs	11/14/19	0.00 0.00	Packaging 2 - 36 - B4B	
				QC 6 - 9	DAS
				QC 6 - 68	NOV 07 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
180 Packaging 3-1 - Stock - B4B	6 pcs	11/14/19	0.00 0.00	QC 6 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190 QC 21 - SA	6 pcs	11/14/19	0.00 0.00	Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	NOV 11 2019
				QC 21 - SA - 53	9-89

Part Op 100 - Waterjet 2 OMAX (Waterjet 2) 1-Cut as per DWG. DWG. Rev: 2 PROG. Rev: 2 2-Deburr if

Descriptions: necessary

110 - QC2- Inspect parts off machine FAI/FAIB

120 - 1-Machine as per DWG. (hole and legs). 2-Deburr 3-Apply LPS-3 to ALL steel parts

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - -Issue P/O; 44995 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of

Conformity is required

160 - Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

GA144

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-B-1.250X6.000	Hot Rolled Steel Bar, 1.250" Wide X 6.000" Thick	1.7400 ft (.29 ea)	100-Waterjet - Omax - 1	S190206

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-HRS-B-1.250X6.000	2	6	0

Part Specifications

Specifications could not be found.

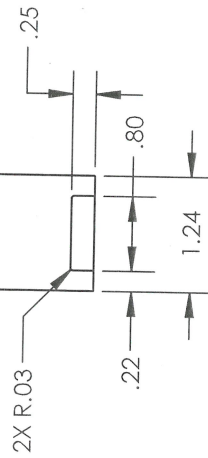
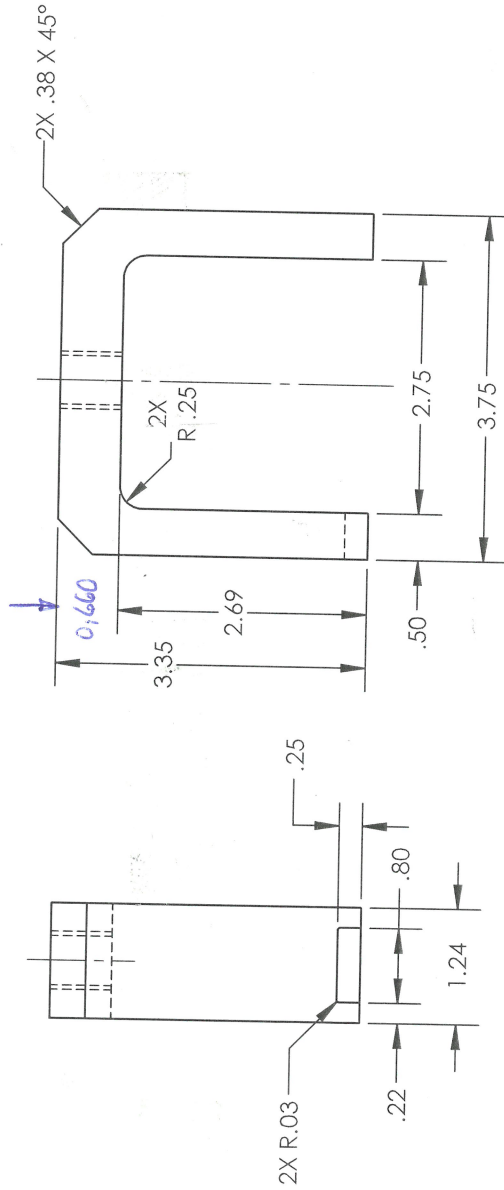
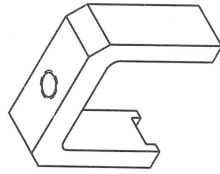
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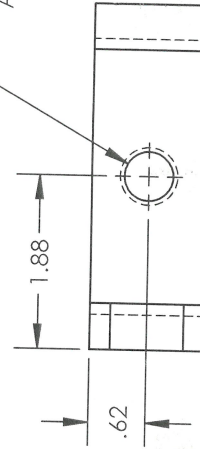
REV	ECR	DESCRIPTION
2	15-0300	4 CHD MATERIAL CALLOUT WAS 1018 IS 1018/1020.

REVISIONS

DATE	INITIAL	APPROVED
9/14/2015	RJC	JAG



5/8-11 UNC - 2B THRU ALL
ALLOW FOR PLATING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 200570



TITLE PULLER-LUBE OIL FILTER CAP

DWG NO.

RB6798860-4

REV 2

MAT'L 1018/1020

DRAWN BY: GILBERT

APPROVED

2 Mod

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

XXX ± .005 FRACTIONS ± 1/8

XX ± .01 ANGLES ± 5°

X ± .1

1. BREAK ALL SHARP EDGES .015 X 45°

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

HEAT TREAT

CAD PLATE YELLOW

SPEC QQ-P-416, TYPE II, CLASS II

USED ON MODEL

ROLLS ROYCE 250

SCALE 1:2

DATE 6/20/2012

SHEET 3 OF 5

(-4)

BRIDGE

0.467 -> 0.762



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044995



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044995

PO Date: 11/4/19

Due Date: 11/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-05

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200568	8NR-49	8NR-49 Rev 2	Stiffener 2 Hole -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/12/19	10 pcs	0 pcs	10 pcs	\$5.25/pcs	\$52.50
2	199669	RBE105- 14102W2-3	RBE105-14102W2 Rev 1	Connecting Pin -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/12/19	6 pcs	0 pcs	6 pcs	\$3.50/pcs	\$21.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044995



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	194212	RBBP-1404-1-3	RBBP-1404-1 Rev 2	Weldment -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/12/19	10 pcs	0 pcs	10 pcs	\$9.00/pcs	\$90.00
4	200570	RB6798860-4	RB6798860 Rev 2	Bridge -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/12/19	7 pcs	0 pcs	7 pcs	\$5.25/pcs	\$36.75
Grand Total:											\$200.25	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Certificat de Conformité / Certificate of Compliance

(023818-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

023818 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.		
06-Nov-2019		Jigar Patel				POHB044995		
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBE105-14102W2-3 Rev.	RBE105-14102W2 1 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2,SC - 2 0.0003 "	ZINC CH	6	6	0	0	0
4	RB6798860-4 Rev.	RB6798860 2 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2,SC - 2 0.0003 "	ZINC CH	7	7	0	0	0

DAS
68
9-89

RECEIVED
 NOV 07 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. J. 1

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: LCDate: Nov 19/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7737Route update only ☐Job: 200570Part No. RB6798860-4

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☒

DEPARTMENT/PROCESS

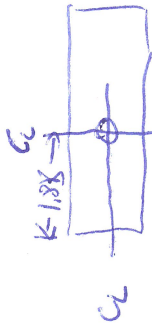
Skid-tube
Machining ☐
Large Fab ☐Cross tube
Small Fab ☐
Finishing ☐Eng. (Non-AW)
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐Engineering ☐
Water Jet ☐
Supplier ☒
Quality ☐Date: 19/10/21Sequence #: 120QTY Affected: 8

Description Work Order Deviation

Raw Material thickness is under tolerance by 0.005 of minimum thickness tolerance.

x ignore drawing detail for hole location

Drill hole at center-line of material thickness



Disposition

Acceptable per deviation

DAS(QS1042)
51
9-89/19/10/21Completed By
19/10/22Lead hand / Supervisor
D.A. 19-10-25QC / QA Coordinator
19/10-28

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☒
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Grimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: ☐Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐Positioned Wrong ☐
Outside Tolerance ☒
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Mistread ☐